



Dart Hawkesbury
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Canada

Tel (613) 632-5200

Dec 19, MA

D5951
Job Sheet 168494



Part No: D5951

Job Qty: 4 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/4/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:E Re-Format 05-11-29 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/1/17	0.00	0.00	Start Up Machining		SBL 17/12/10
100	CNC Vertical Machining	4 pcs		12/2/17	0.54	12.12	HAAS 1		FK 17-12-12
110	QC	4 pcs		12/2/17	0.00	0.00	QC1		FK 17-12-12
120	QC	4 pcs		12/2/17	0.00	0.00	QC8		J.C.L. 17-12-15
130	HandFinish	4 pcs		12/2/17	0.00	0.31	HandFinish1		BEB 17/12/16
140	Powdercoat	4 pcs		12/4/17	0.00	0.21	Powdercoat1		FK 17-12-19
150	QC	4 pcs		12/4/17	0.00	0.00	QC3		38
160	Packaging	4 pcs		12/4/17	0.00	0.00	Packaging3	rel	ST399
170	QC21-SA	4 Ea		12/4/17	0.00	0.00	QC21		21 DEC 20 2017

Part Op 100 - 1-Machine as per folio D5951. Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble
Descriptions: 140 - START TIME: 8:20 O.V.T: 3:30 FINISH 8:50.

M 138467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-013	4	7	0	0

Part Specifications

Specifications could not be found.

Plex 11/15/17 3:03 PM dart.poulin.mario

DART AEROSPACE LTD		Work Order:	168494
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.316	.316	.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.316	.316	.316		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.501	.499	.500	.499		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.001	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.497	.500	.500		
T	1.375	1.395		1.380	1.380	1.380	1.380		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	FK
Date:	17-12-12

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	